

Work Order ID 79167

79167

Page 1

January-23-12 10:42:51 AM

Item ID: D2804-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket Assembly
 Start Date: 23/01/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 06/02/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 12/01/23 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2804	Rev C

100	Small Fab	0.00							
100									
Small Fab	Memo	0.00							
Small Fab	Press D2805-2 into arm as per Dwg D2804								

Signature 12/02/08

110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									

Signature 12/02/08

Signature

120	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
120									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <u>10:40</u> OVEN TEMPERATURE:								
	FINISH TIME: <u>11:10</u>								

Signature 12/02/09

W 119480

32001

11:10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC3- Inspect Part Finish	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Small Fab	0.00							
140									
Small Fab	Memo	0.00							
Small Fab	Press Fit D2809 as per Dwg D2804								
150	Small Fab	0.00							
150									
Small Fab	Memo	0.00							
Small Fab	1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804 2-Assemble as per Dwg D2804.								

4 6 11 12 02 109

EP 12/02/28 (4)

EP 12/02/28 (4)

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <i>G.A</i>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

Sp 12/02/28 (4)

12/02/28 (4)

12/2/29 (4)

muf
12-02-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 79167

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Parent Item: D2804-042

D2804-042

Parent Item Name: Bracket Assembly

Start Date: 23/01/2012

Required Date: 06/02/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP F05.03.30MS21043-3 was MS21042L3 KJ/JLM
IPP Rev:G As per Rev C 06-11-08 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2804-2		Manufactured	No			100	Each	0.0000	1	4			
D2804-2													
Bracket													
D2805-2		Manufactured	No			100	Each	6.0000	1	4			
D2805-2													
Stop													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		6							
				76186		6							
NAS1515H3		Purchased	No			100	Each	147.0000	4	16			
NAS1515H3													
Washer													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST277		147							
				116373		2							
				118078		6							
				118384		11							
				119438		28							
				120142		100							
AN3C16A		Purchased	No			150	Each	60.0000	2	8			
AN3C16A													
Bolt													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST352		60							
				115835		1							
				118422		4							
				118628		13							
				119641		42							

B 79180 (4K) ~~B 77602 (4K)~~ **

EP 12/02/08

**

EP 12/02/08

B 79526 (4K)

**

EP 12/02/08

M120518
162

**

EP 12/02/08

M120769
200

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 79167

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Parent Item: D2804-042

D2804-042

Parent Item Name: Bracket Assembly

Start Date: 23/01/2012

Required Date: 06/02/2012

Start Qty: 4.00

Required Qty: 4.00



D2809

Manufactured No

150

Each

29.0000

1

4

D2809

Bushing

**

Handwritten signature
12/02/12

Location

Loc Qty

Loc Code

GA

7

72735

7

ST018

22

34035

12

77292

10

Handwritten: 380557. (4x)

MS21043-3

Purchased

No

150

Each

1,193.000

2

8

MS21043-3

Nut

**

Handwritten signature
12/02/12

Location

Loc Qty

Loc Code

FG

72

103691

72

ST300

582

119901

582

ST301

539

118077

2

118614

441

118686

30

119758

66

Handwritten: M120693
(4x)

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

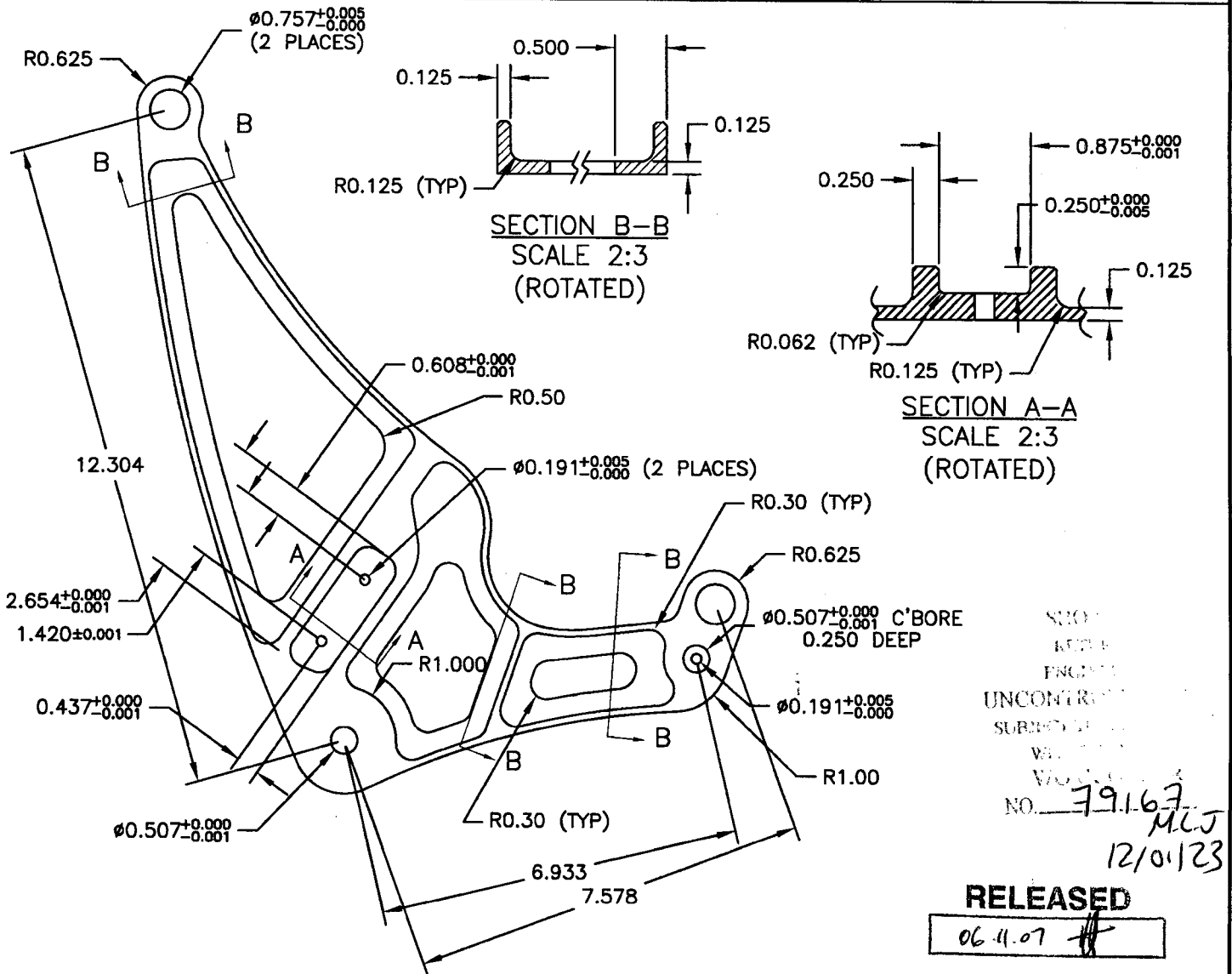
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D2804	REV. C SHEET 1 OF 2
DATE	06.10.16			TITLE STA 155 BRACKET	SCALE 1:3
A	00.11.07			NEW ISSUE	
B	04.11.22			ADD CUTOUTS & -043/-044	
C	06.10.16			CHANGE GEOM. TO ADD CLEARANCE	

**D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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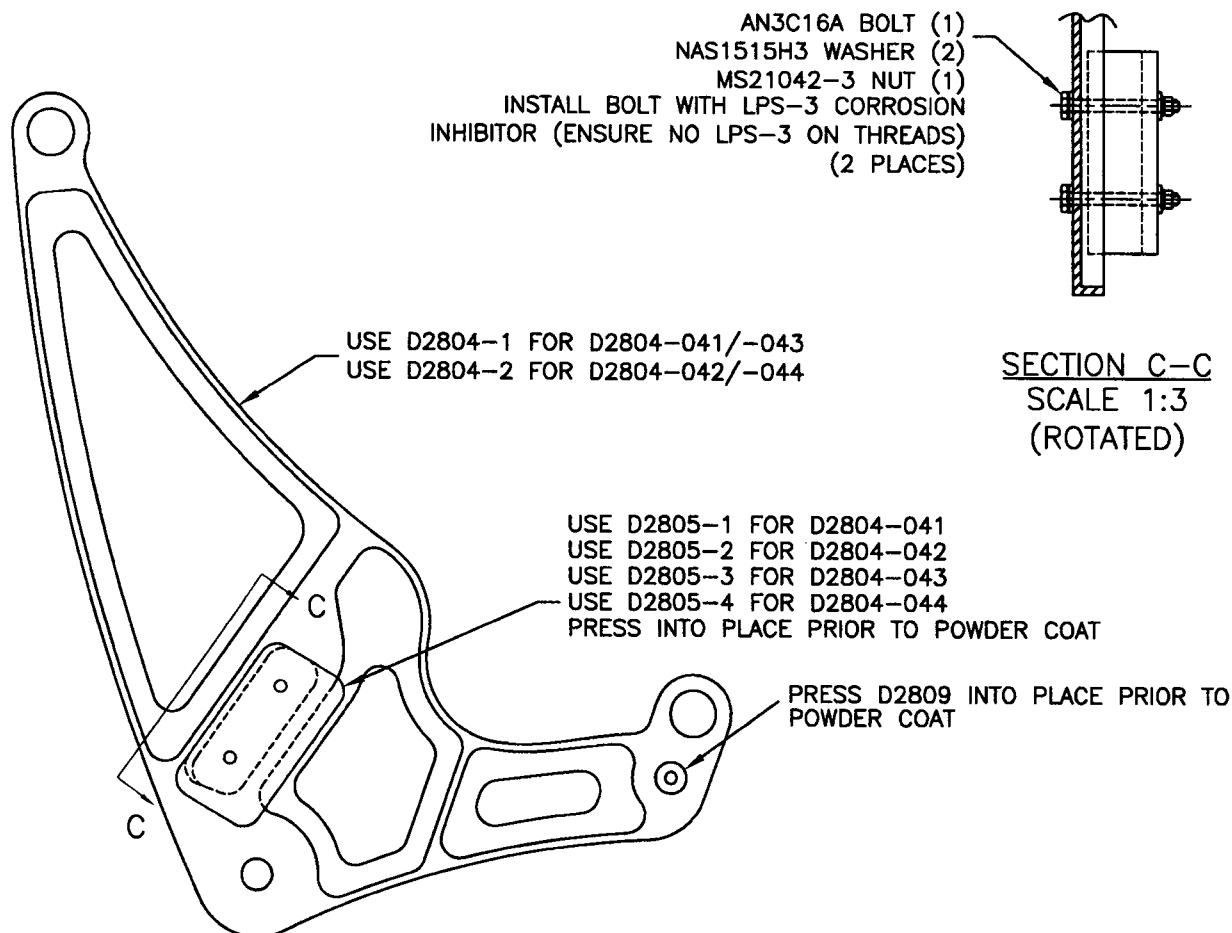
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79167

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3



SECTION C-C
SCALE 1:3
(ROTATED)

RELEASED

06.11.07

D2804-041/-043 BRACKET ASS'Y (SHOWN).

D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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